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**Fu et al.**

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(54) **METHOD OF FORMING FOOD PRODUCT**

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**A23P 1/10** (2006.01)

(52) **U.S. Cl.** ..... **426/503**; 426/512; 426/518; 425/299

(58) **Field of Classification Search** ..... 426/496, 426/499, 502, 503, 512, 514, 517, 518; D1/122-124, D1/128; 101/3.1-32; 425/298-300  
See application file for complete search history.

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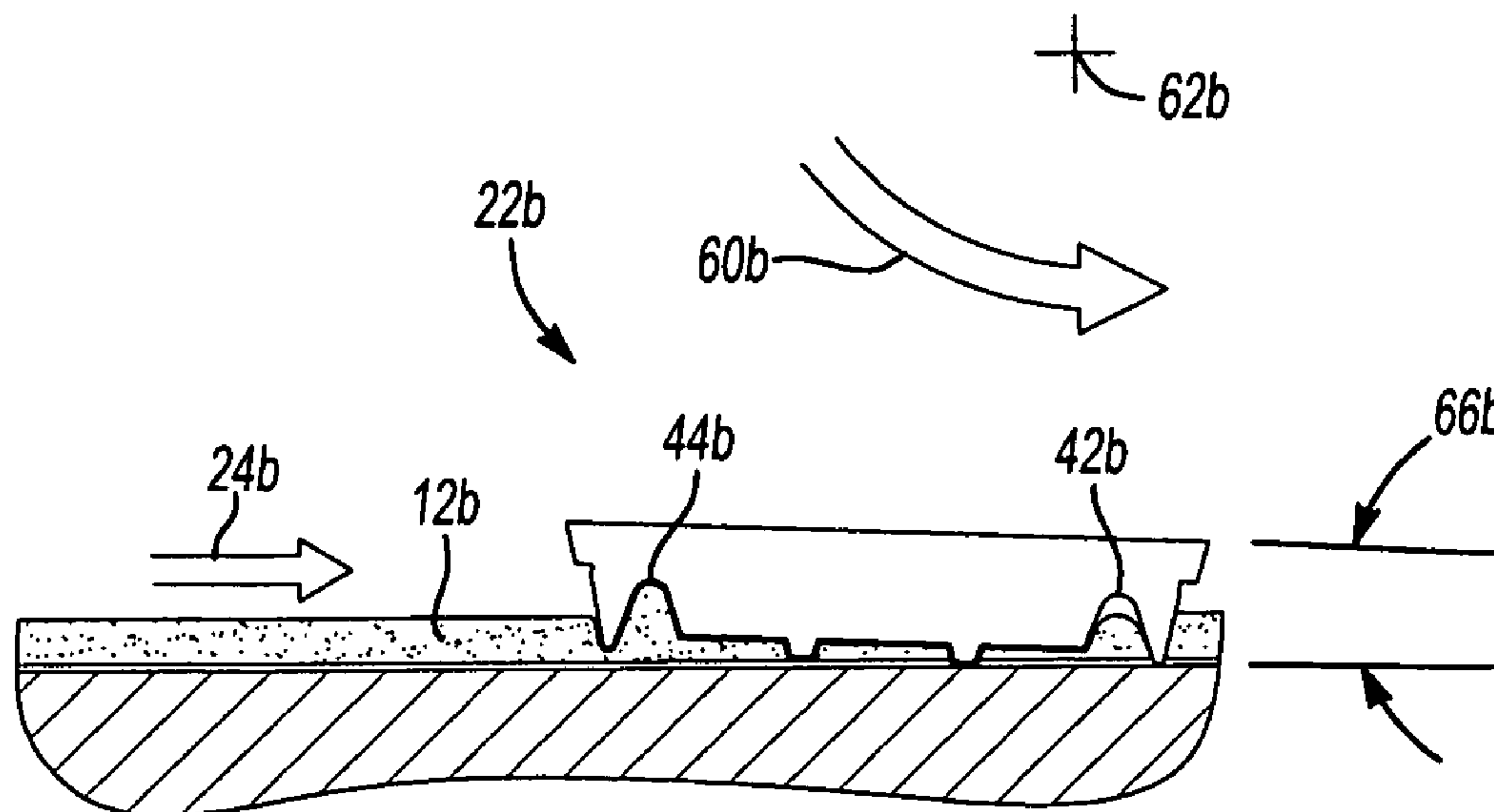
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(57) **ABSTRACT**

The invention provides a method of forming an edible item. The method includes the step of forming dough into a substantially planar ribbon having a first height. The dough is at least partially elastic. The method also includes the step of permanently displacing a portion of the at least partially elastic ribbon to a second height greater than the first height with a cutting die. The inventive method can produce a cracker formed from sheetable dough. The inventive cracker includes a first portion of planar configuration and a second portion integrally formed with and raised from said first portion.

**12 Claims, 5 Drawing Sheets**



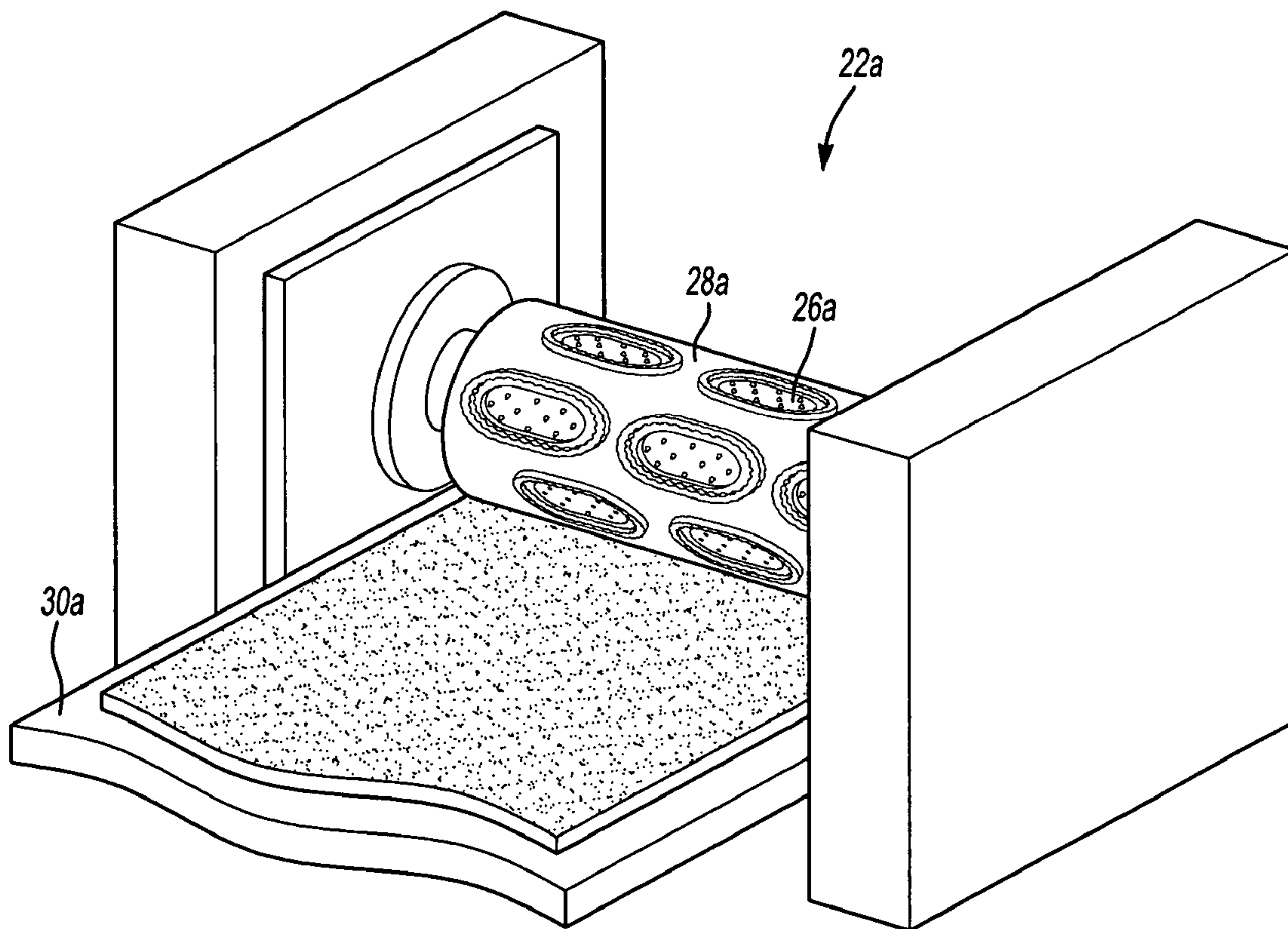
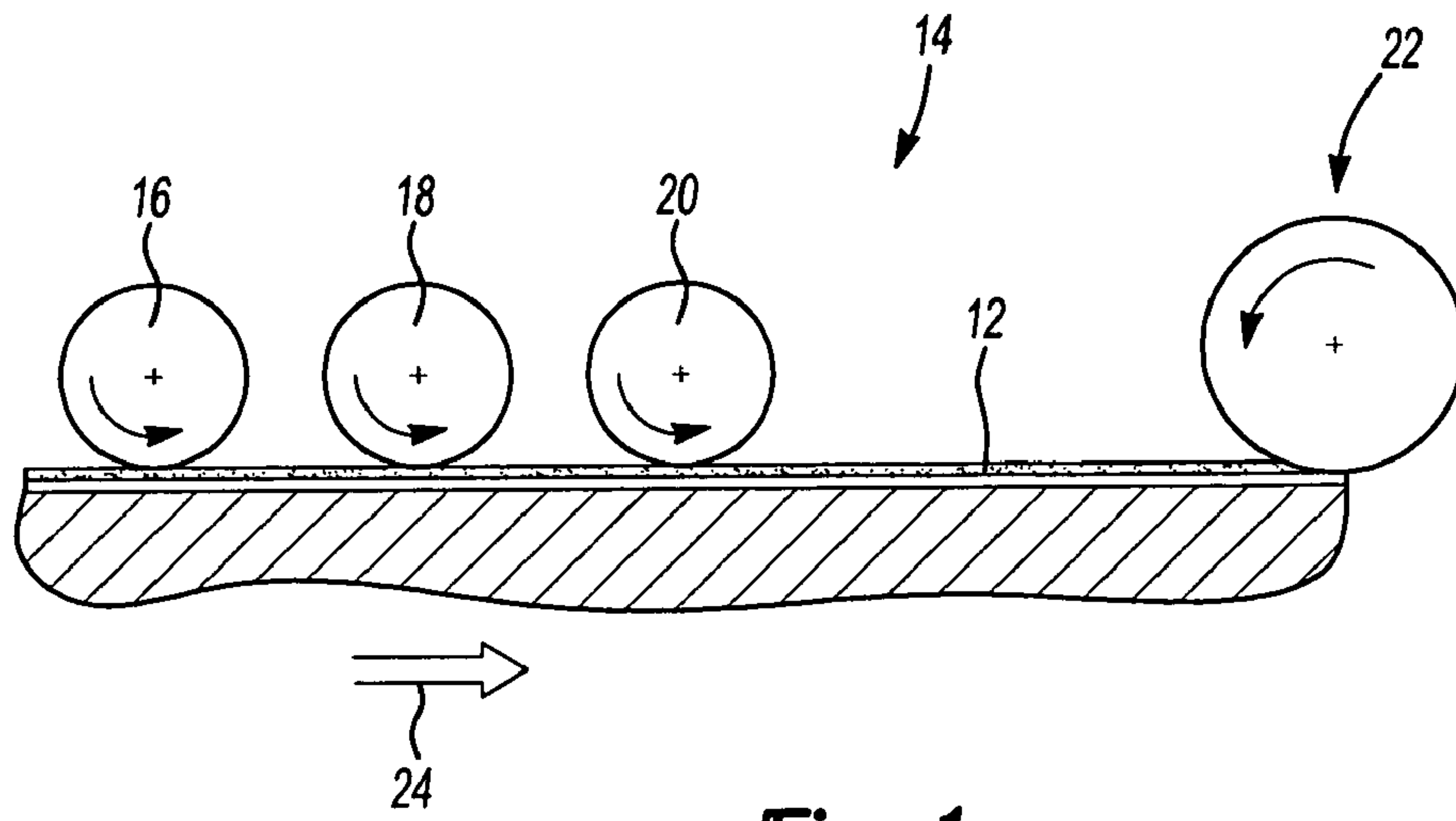
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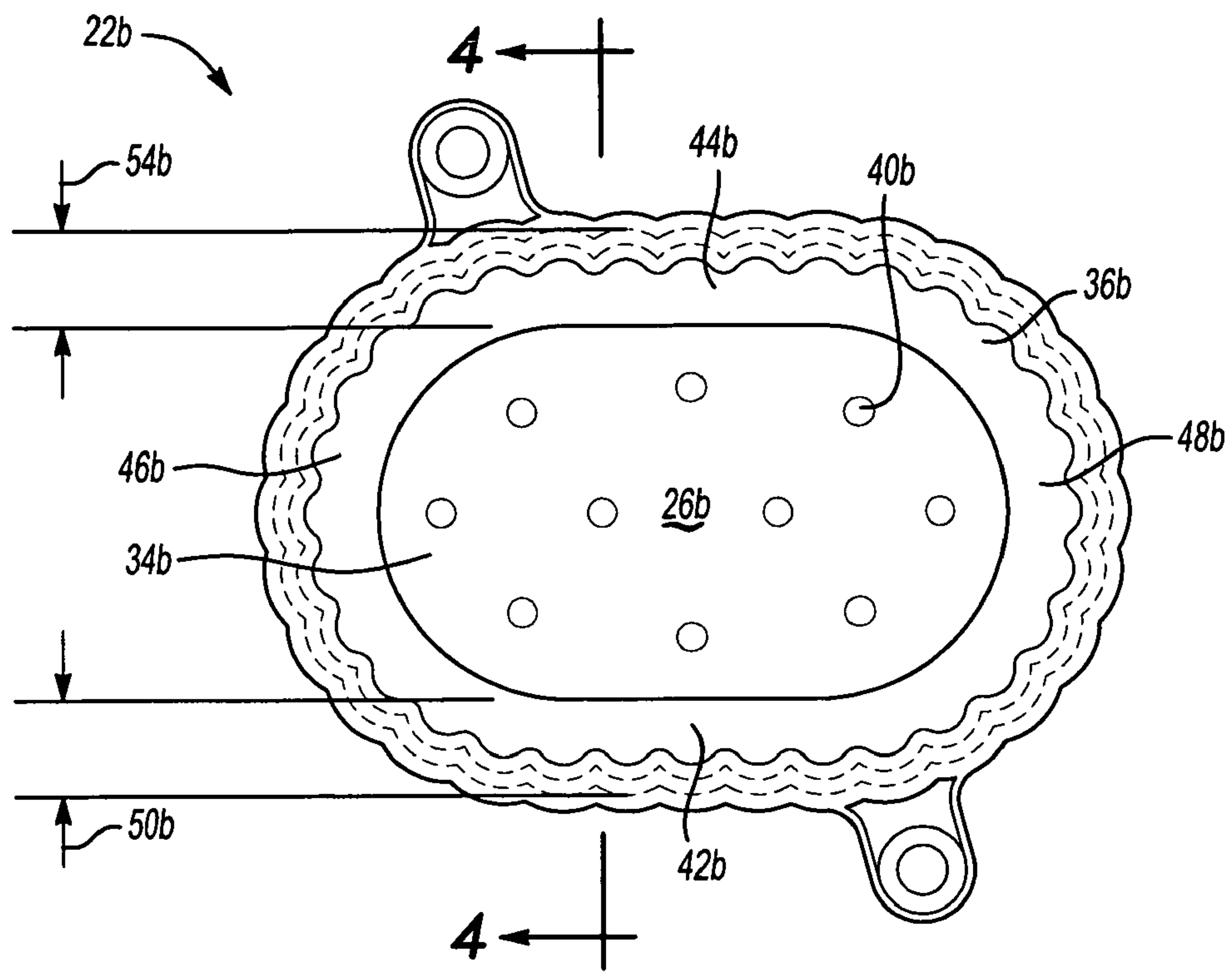
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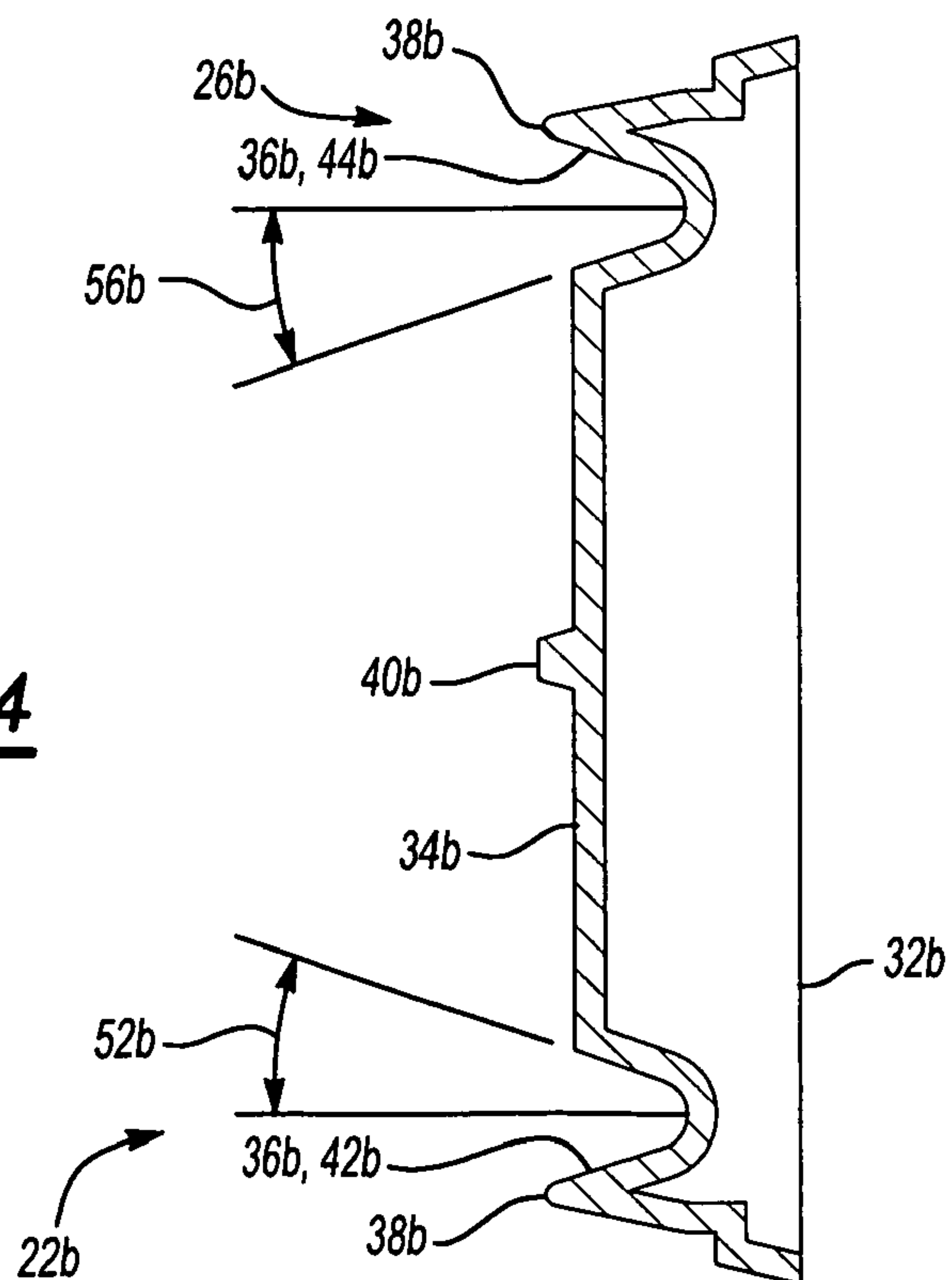
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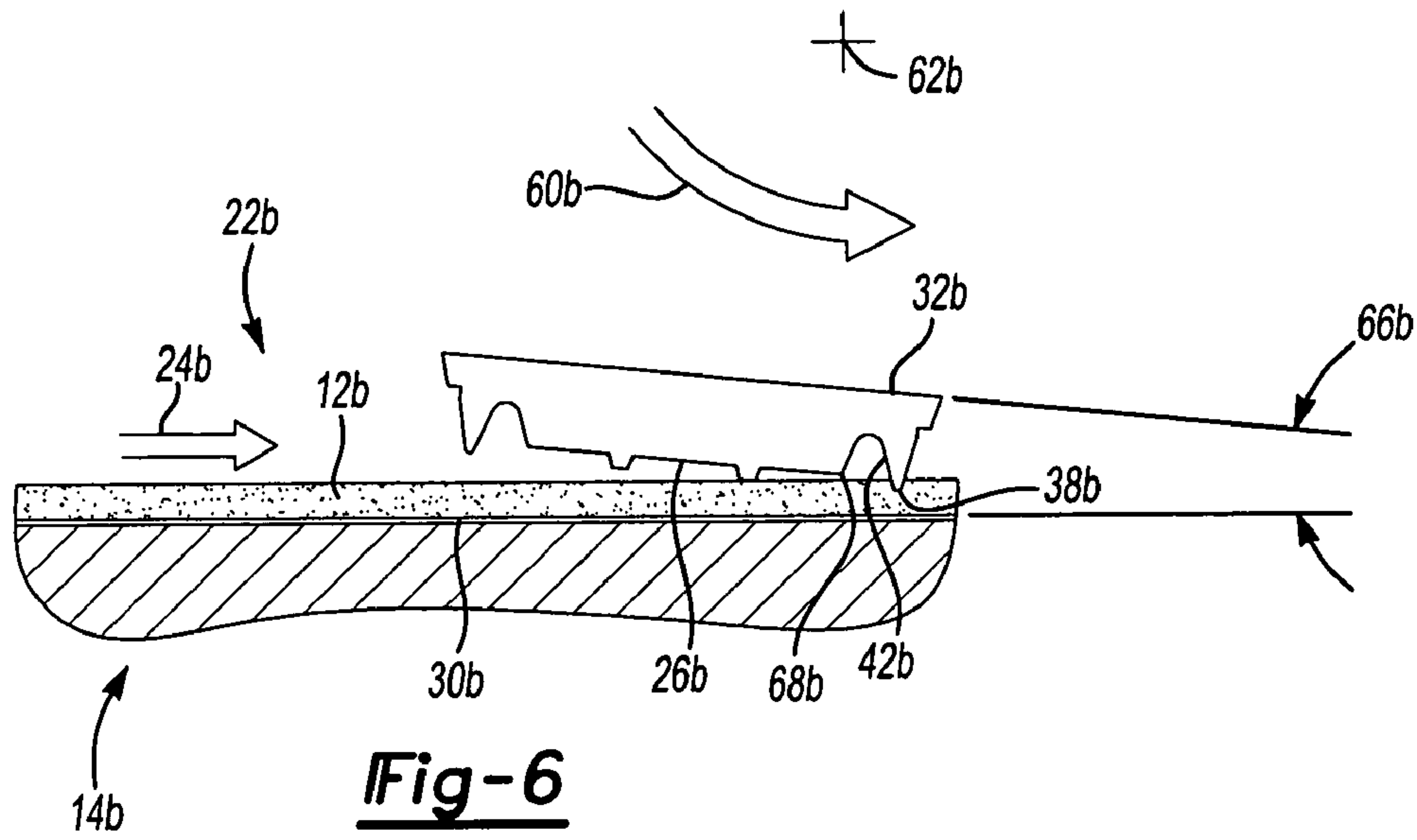
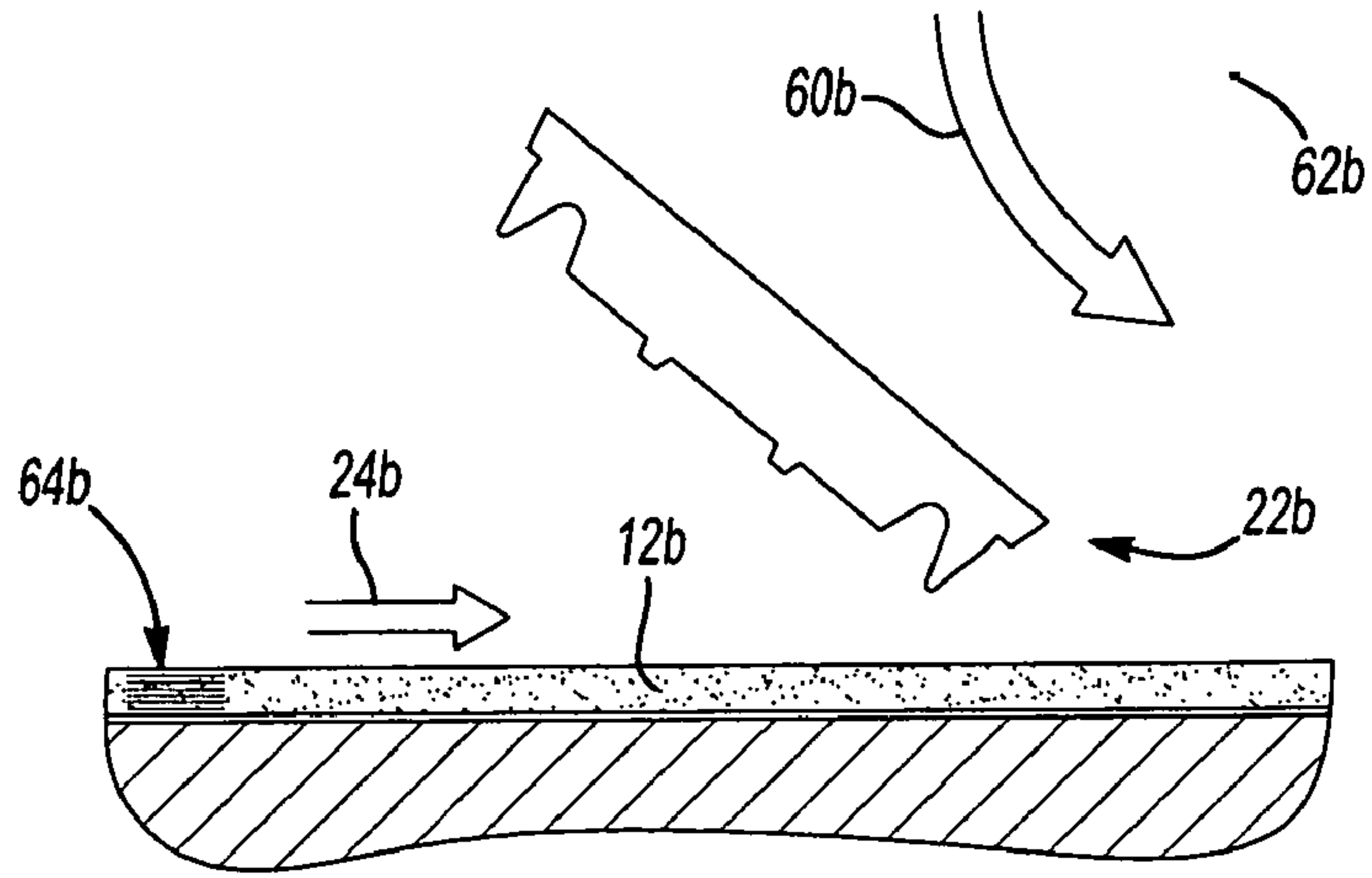


**Fig-3**

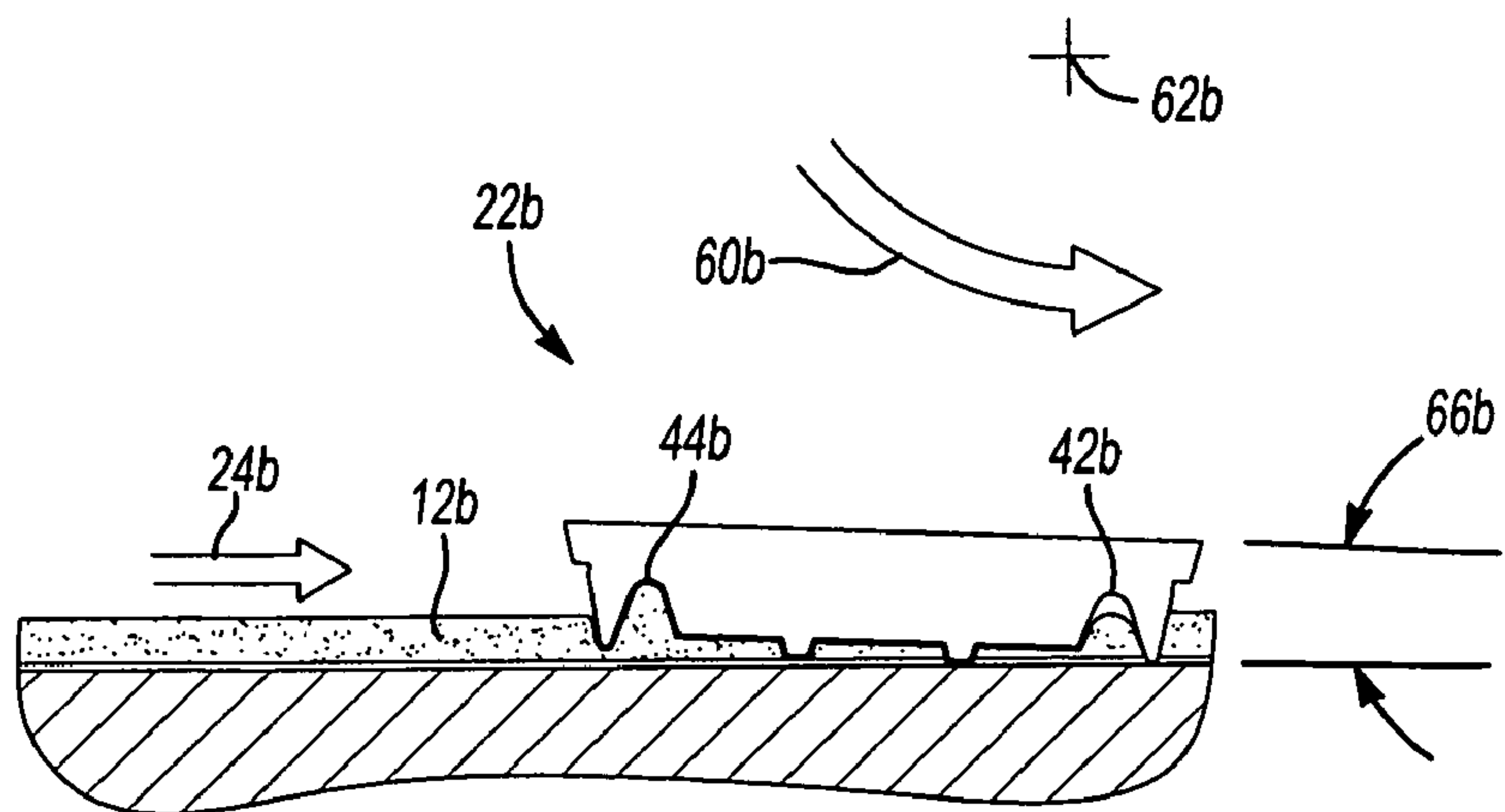


**Fig-4**

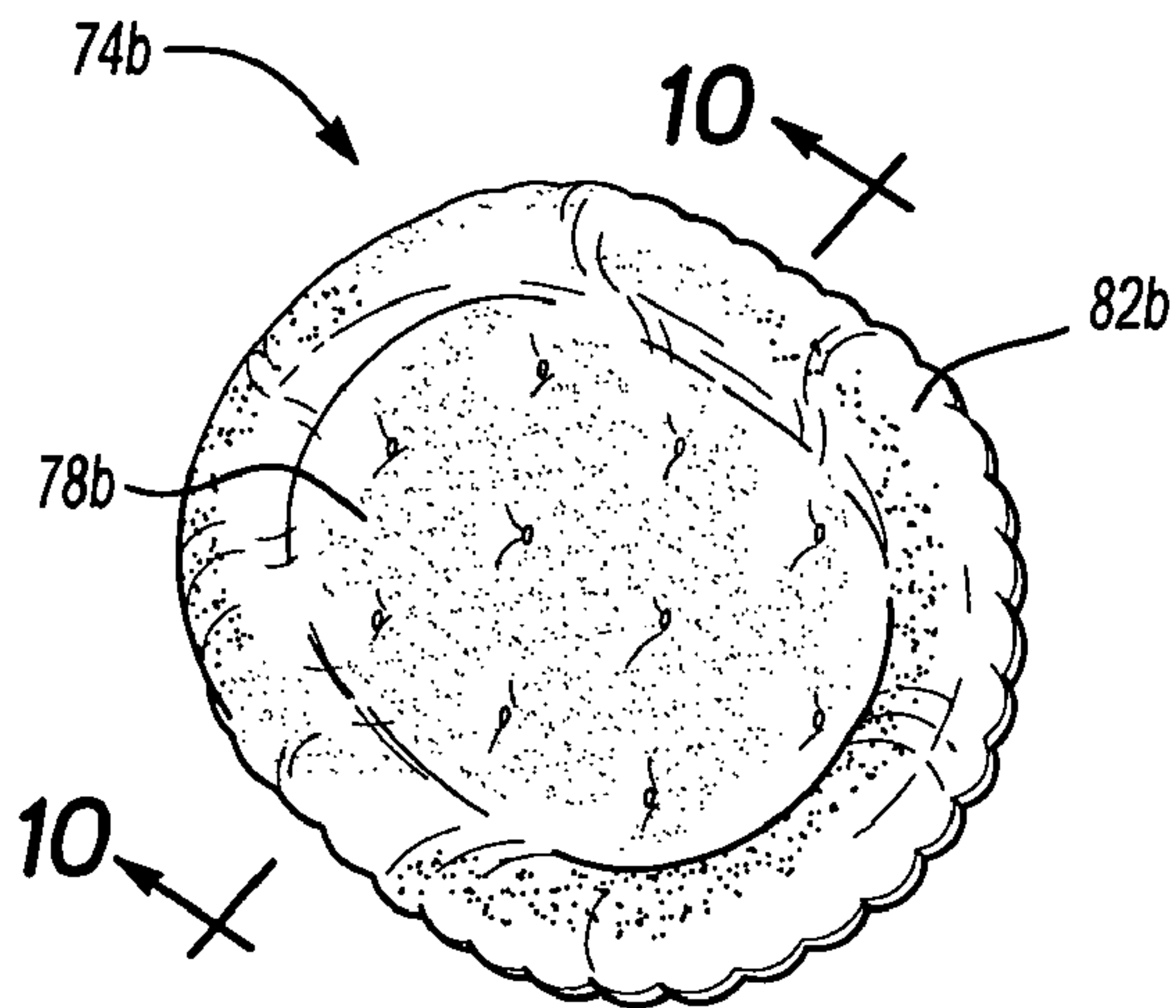
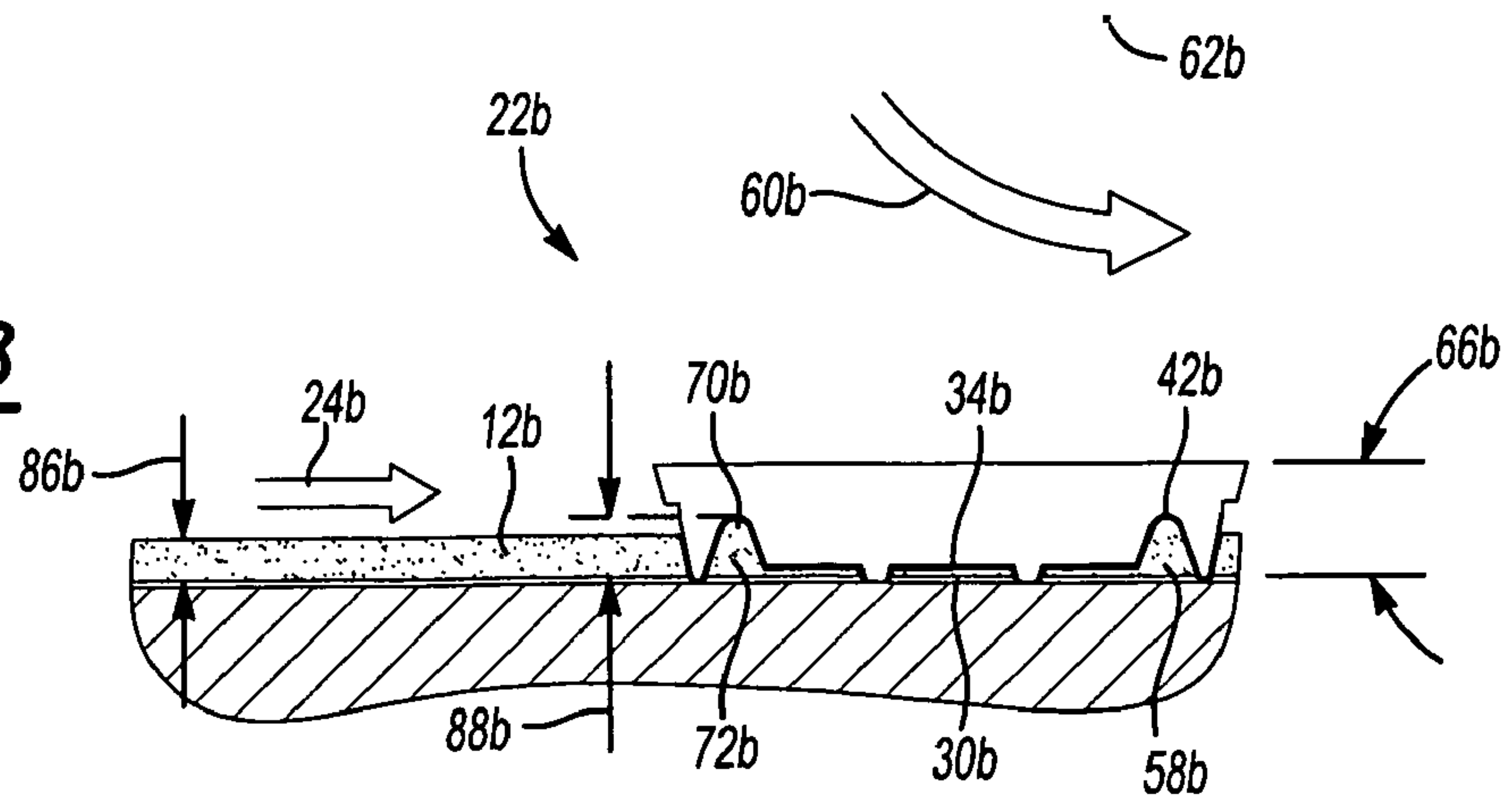
**Fig-5**



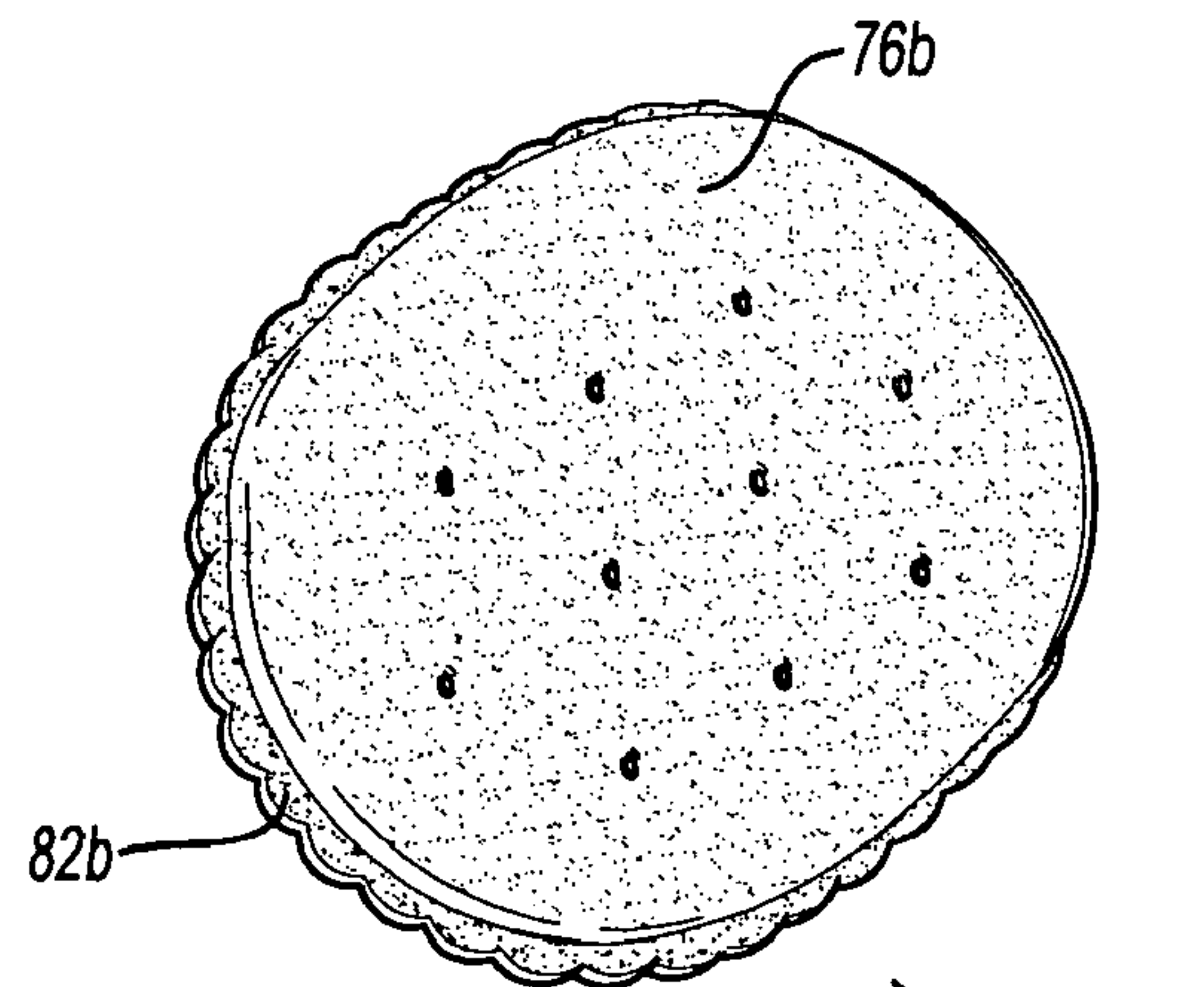
**Fig-7**



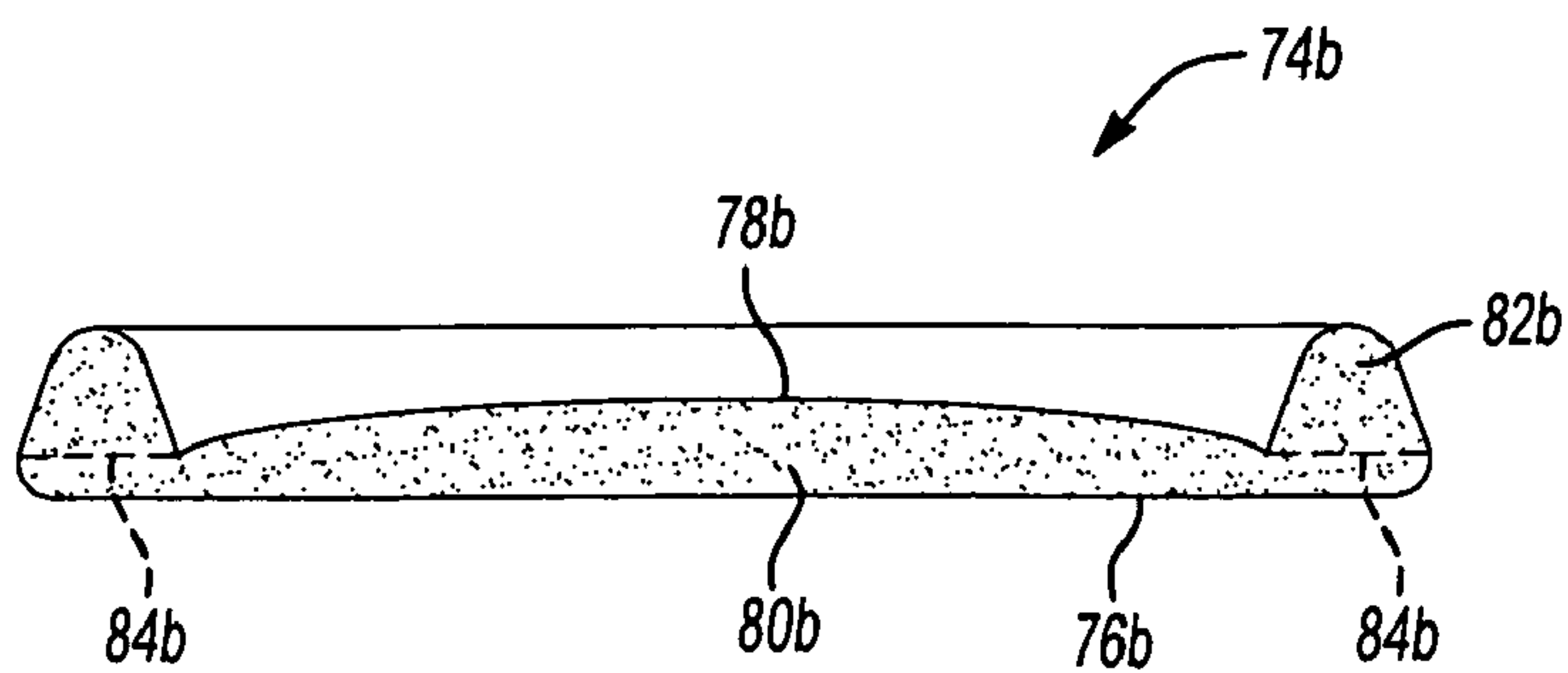
**Fig-8**



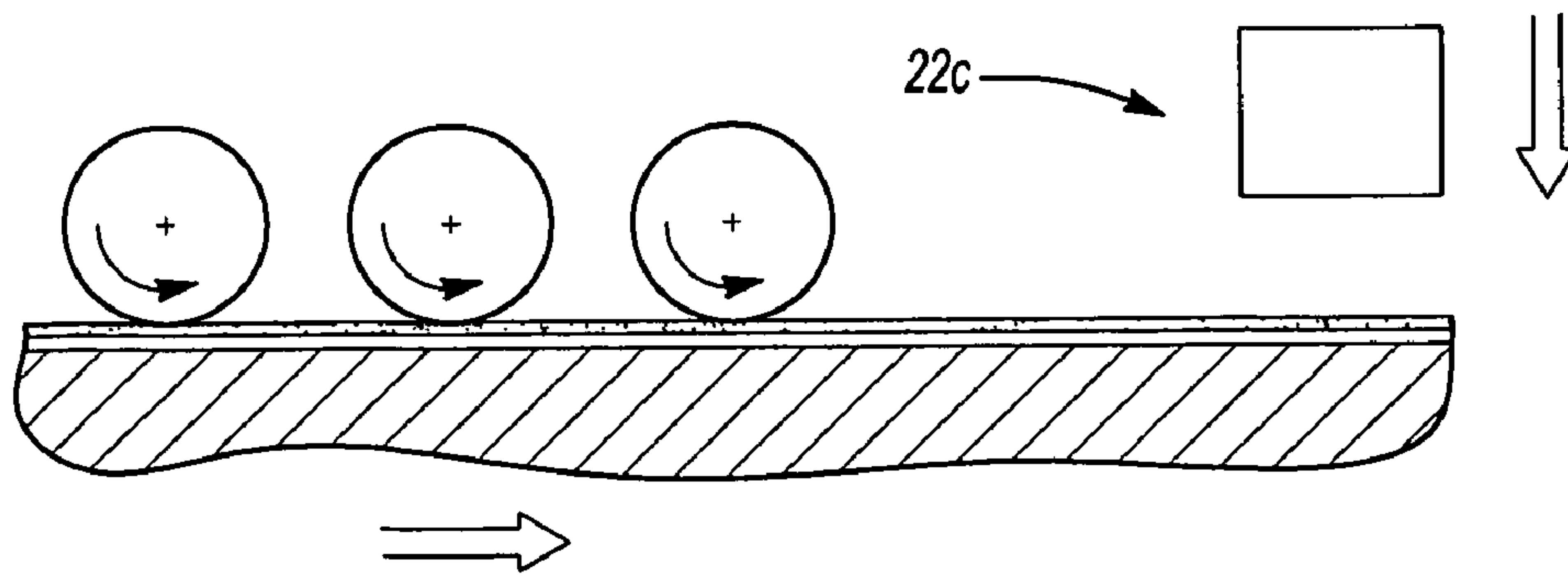
**Fig-9**



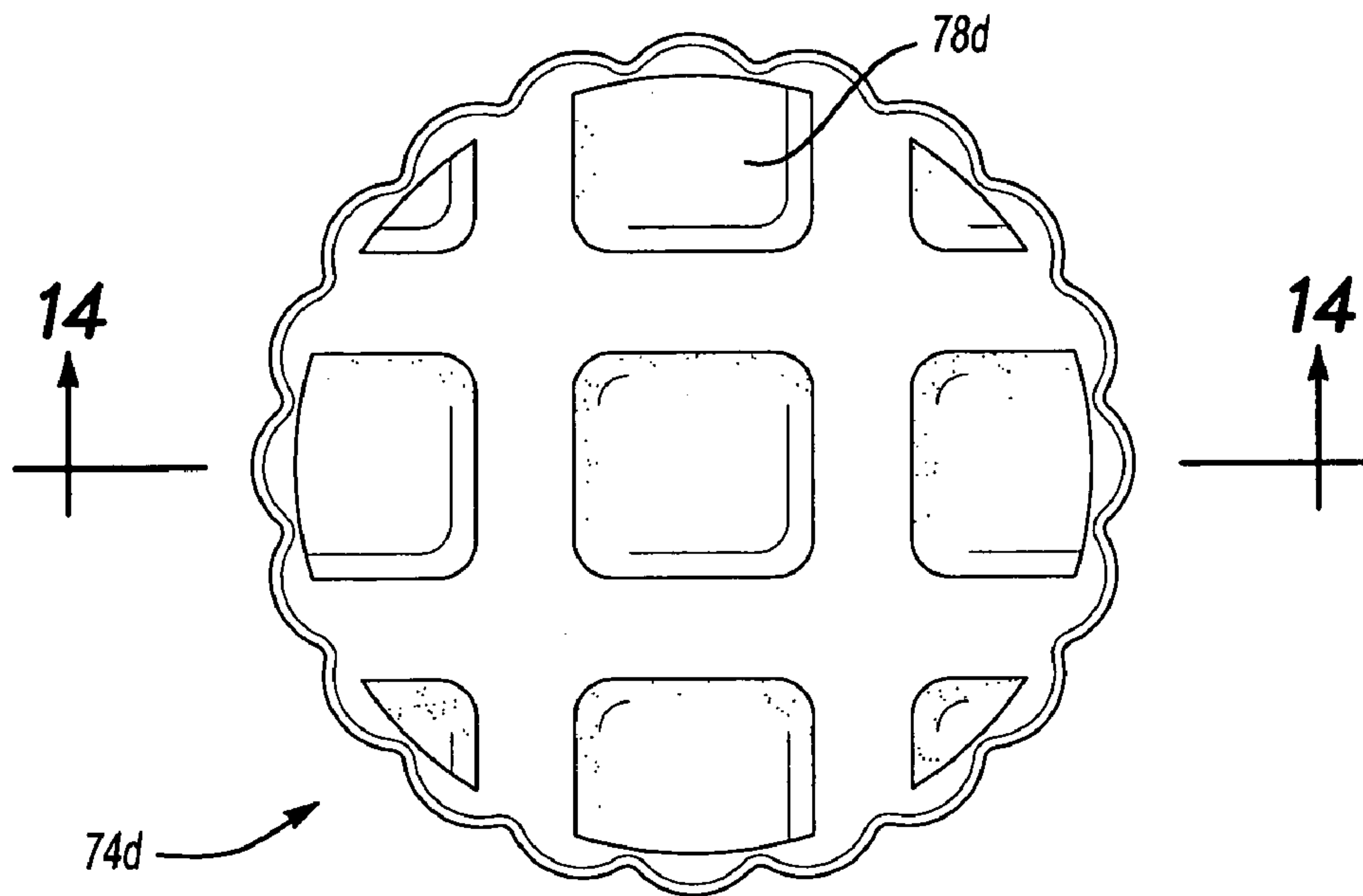
**Fig-11**



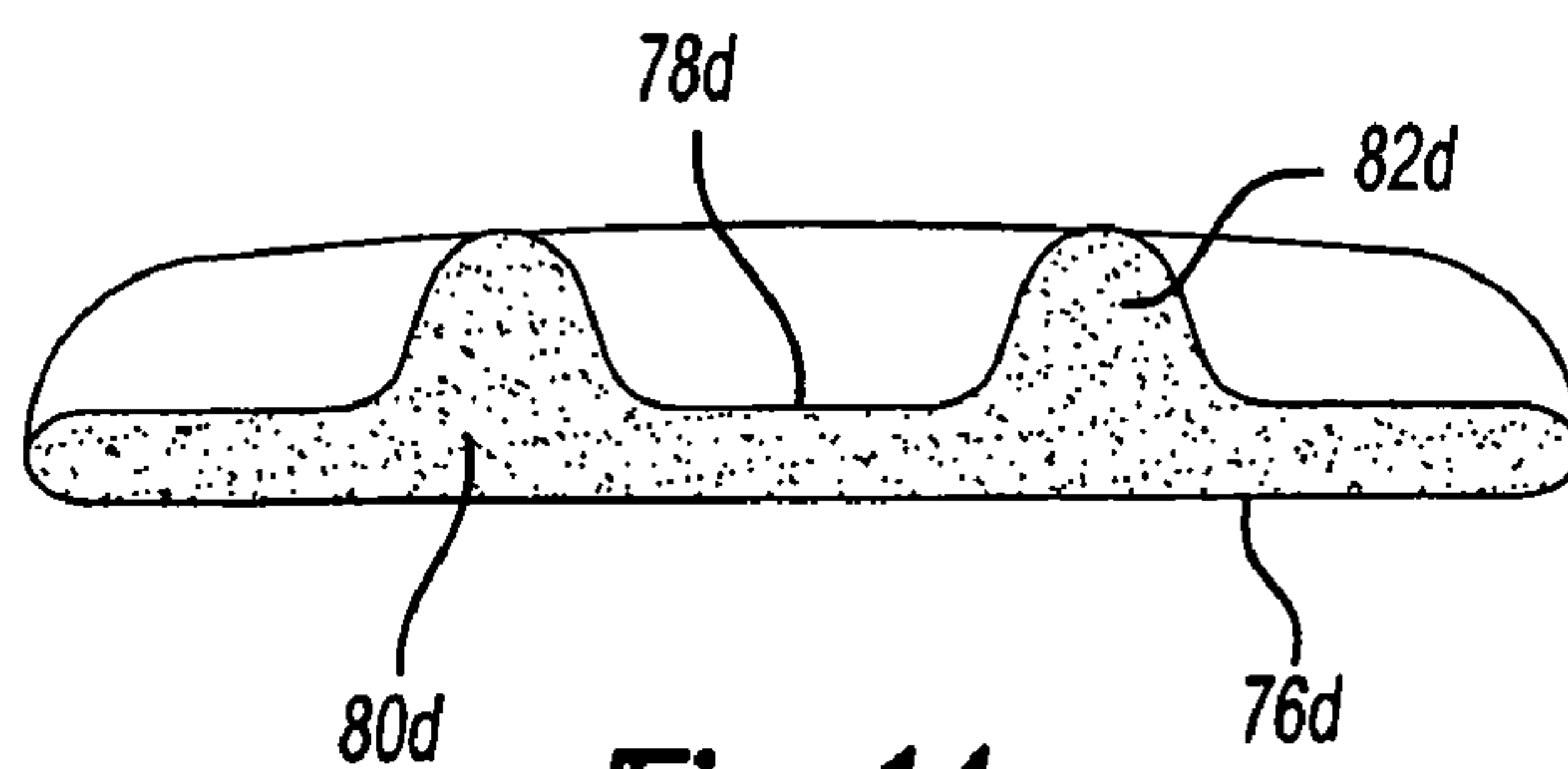
**Fig-10**



**Fig-12**



**Fig-13**



**Fig-14**



**METHOD OF FORMING FOOD PRODUCT****CROSS-REFERENCE TO RELATED APPLICATIONS**

This application claims the benefit of U.S. Provisional Patent Application Ser. No. 60/690,757 for a TUB OR CUP SHAPED CRACKER, filed on Jun. 15, 2005, which is hereby incorporated by reference in its entirety.

**BACKGROUND OF THE INVENTION****1. Field of the Invention**

The invention relates to a tub-shaped food product formed from a ribbon of dough with a cutting die, such as biscuits, crackers or cookies.

**2. Description of the Related Art**

U.S. Pat. No. 4,562,084 discloses extruding a plurality of parallel ribbons of cookie dough extrudate onto a first conveyor belt, cutting the ribbons in a staggered pattern to form individual cookie preforms, and feeding the preforms onto a second conveyor belt moving at a speed at least twice that of the first conveyor belt in order to separate successive preforms by at least the length of a cookie preform. U.S. Pat. No. 859,999 discloses a machine for making cookies. U.S. Pat. No. 2,813,033 discloses a method for packaging or preparing a group of formed pieces of edible doughy material ready for cooking.

**SUMMARY OF THE INVENTION**

The invention provides a method of forming an edible item. The method includes the step of forming dough into a substantially planar ribbon having a first height. The dough is at least partially elastic. The method also includes the step of permanently displacing a portion of the at least partially elastic ribbon to a second height greater than the first height with a cutting die. The inventive method can produce a cracker formed from sheetable dough. The inventive cracker includes a first portion of planar configuration and a second portion integrally formed with and raised from said first portion.

Other applications of the present invention will become apparent to those skilled in the art when the following description of the best mode contemplated for practicing the invention is read in conjunction with the accompanying drawings.

**BRIEF DESCRIPTION OF THE DRAWINGS**

FIG. 1 is a schematic view of a first exemplary embodiment of the invention;

FIG. 2 is a perspective view of a cutting die according to a second exemplary embodiment of the invention;

FIG. 3 is a top view of a cutting die according to a third exemplary embodiment of the invention;

FIG. 4 is a cross-sectional view of the cutting die according to the third exemplary embodiment of the invention taken along section lines 4-4 in FIG. 3;

FIG. 5 is a first process detail view wherein the cutting die according to the third exemplary embodiment of the invention is shown moving into engagement with a ribbon of dough;

FIG. 6 is a second process detail view occurring after the first process detail view of FIG. 5 wherein the cutting die is shown initially engaging the ribbon of dough;

FIG. 7 is a third process detail view occurring after the second process detail view of FIG. 6 wherein the cutting die is shown further engaging the ribbon of dough;

FIG. 8 is a fourth process detail view occurring after the third process detail view of FIG. 7 wherein the cutting die is shown fully engaging the ribbon of dough to form a substantially discrete piece of dough from the ribbon;

FIG. 9 is a top perspective view of a tub-shaped food product formed by the third exemplary cutting die;

FIG. 10 is a cross-sectional view of the tub-shaped food product taken along section lines 10-10 in FIG. 9;

FIG. 11 is a bottom perspective view of the tub-shaped food product shown in FIGS. 9 and 10;

FIG. 12 is a schematic view of a fourth exemplary embodiment of the invention;

FIG. 13 is a top view of a food product formed by another embodiment wherein the raised portion is forms a grid pattern; and

FIG. 14 is a cross-sectional view taken along section lines 14-14 in FIG. 13.

**DETAILED DESCRIPTION OF A PREFERRED EMBODIMENT**

A plurality of different embodiments of the invention are shown in the Figures of the application. Similar features are shown in the various embodiments of the invention. Similar features have been numbered with a common reference numeral and have been differentiated by an alphabetic designation. Also, to enhance consistency, features in any particular drawing share the same alphabetic designation even if the feature is shown in less than all embodiments. Similar features are structured similarly, operate similarly, and/or have the same function unless otherwise indicated by the drawings or this specification. Furthermore, particular features of one embodiment can replace corresponding features in another embodiment unless otherwise indicated by the drawings or this specification.

The present invention can be practiced to produce a snack such as a cracker with raised edges. Dough is formulated to make the snack such that the dough can be formed into a ribbon. Thus, the dough is at least partially elastic, unlike cookie dough. The dough has an open cell structure and products formed from the dough will be lighter and less dense than products made from "non-ribbonable" dough such as cookie dough. However, the dough is also formulated to be permanently extendable without tearing to form of a discrete food piece with a raised portion. Exemplary types of dough are set forth and described in U.S. Pat. No. 6,267,998, which is hereby incorporated by reference in its entirety. In the exemplary embodiment of the invention set forth below, a cracker is formed with a portion of planar configuration and a portion raised from the planar configuration. A trough is defined by the raised portion and an upper surface of the planar portion. It can be desirable to dispose toppings such as dips and spreads in the trough.

The inventive method includes the step of forming dough into a ribbon. FIG. 1 shows a ribbon 12 of dough moving along a production line 14. A plurality of rollers 16, 18, 20 and a cutting die 22 are disposed along the production line 14. The ribbon 12 is formed from dough that is at least partially elastic and sufficiently strong to be formed as a ribbon, but also sufficiently flexible to be moved in the cutting die 22 as set forth below.

The dough can be any of a number of flavors, whatever flavor is desired. For example, the dough may include garlic flavor, whole grain flavor, buttery flavor, etc. The dough is formed in a mixer, such as a Peerless® mixer, where ingredients are added in several stages. In the exemplary embodiment of the invention, the following ingredients may be added



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to the mixer in a first stage: any vegetable oil such as a soy/cottonseed oil blend; sweeteners such as high fructose corn syrup, 62 DE corn syrup, and/or fine granulated sugar, granulated salt, sodium sulfite, enzyme, and water. Option-  
ally, flavors can also be added such as malt extract, honey, and  
honey flavor. Flavors may also be added to the ribbon **12** or to  
the discrete dough piece that emerges from the cutting die **22**.

The ingredients that are added in the first stage may be mixed in the mixer for approximately one to five minutes at low speed. In a second stage, the following ingredients may

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is approximately 110 degrees F. The resultant dough temperature, following mixing is approximately 90-100 degrees F. However, other temperatures may also be used to achieve the desired dough consistency. An example of formulas and mixing instructions for "original", "garlic herb", and "honey wheat" dough are included at Table 1 below, where the formula of a "classic" cracker is also provided. A variety of doughs would work for this invention, such as whole grain dough, yeast leavened sponge dough, and sweet dough.

TABLE 1

INGREDIENT	Original %	Garlic Herb %	Honey Wheat %	Classic Cracker %
Vegetable Oils (liquid and/or partially hydrogenated)	9.11%	8.96%	8.17%	8.83%
High Fructose Corn Syrup	0.65%	0.64%	0.58%	0.67%
62 DE Corn Syrup	1.10%	1.09%	0.99%	1.08%
Water	17.71%	17.64%	16.05%	16.74%
Fine Granulated Sugar	4.73%	4.65%	8.76%	4.69%
Granulated Salt	0.72%	0.70%	0.64%	0.82%
Sodium Sulfite	0.017%	0.017%	0.018%	0.012%
Enzyme Tablet	0.011%	0.011%	0.012%	0.006%
Malt Extract	n/a	n/a	0.64%	n/a
Honey	n/a	n/a	1.63%	n/a
Honey Flavor	n/a	n/a	0.58%	n/a
Water (as % of dry ingred)	20-30%	20-30%	20-30%	20-30%
Mix 1-5 mins at Low Speed				
Enriched Flour Blend	61.84%	60.82%	49.62%	65.60%
Corn Starch	3.31%	3.26%	5.84%	n/a
Oat Bran	n/a	n/a	1.46%	n/a
Defatted Wheat Germ	n/a	n/a	3.94%	n/a
Sodium Bicarbonate	0.27%	0.35%	0.35%	0.52%
Acid Leavening Blend	0.53%	0.70%	0.70%	1.03%
Non-Dairy Butter Garlic Flavor	n/a	0.96%	n/a	n/a
Parsley Flakes	n/a	0.19%	n/a	n/a
Garlic Powder	n/a	0.02%	n/a	n/a
Mix 3-9 mins at Low Speed				
	100.00%	100.00%	100.00%	100.00%

be added to the mixer: flour and corn starch or other starches. Other ingredients may include: sodium bicarbonate, acid leavening blend, non-dairy butter garlic flavor, parsley flakes, garlic powder, oat bran, wheat germ, etc. The levels of enzyme and sodium sulfite can be relatively higher than that of other crackers while the levels of soda and leavening acid can be lower than that of other crackers.

The flour may include soft red or white winter wheat varieties. Hard wheat can also be used depending on the desired texture. The flour can be fortified with niacin, iron in reduced form, thiamine in mononitrate form, riboflavin and folic acid. The enzyme can be a microbial, proteolytic enzyme derived from *Bacillus subtilis* also having significant amylase and prolylase activity. The active enzymes will be on a base of food-grade cornstarch and dextrose. Use of the enzyme enables the dough to weaken its gluten structure to be molded as disclosed below. The enzyme could also come from plant or fungal sources.

In the exemplary embodiment of the invention, the mixer is mixed for three to nine minutes at low speed after the second stage of ingredients are added. For some varieties of cracker, a third stage may be carried out wherein the following ingredients are added to the mixer: ammonium bicarbonate and water. The water may be added at a temperature that is preferable 100-120 degrees F. The temperature of the mixer jacket

Cheese dough can also be used with the invention. The table below provides an example for a cheese dough product:

TABLE 2

INGREDIENT/STEP	%
Vegetable Oils (liquid and/or partially hydrogenated)	40.81%
Enriched Wheat Flour	4.68%
Yeast	0.06%
Enzyme	0.03%
Seed SPONGE	0.11%
Water	20-40%
Mix 1-5 mins at Low Speed	
Time to Ferment: 5-24 hr	
Enriched Wheat Flour	27.21%
Hard Wheat Flour	13.60%
Cheese	12.15%
Fine Dough Salt	0.67%
Ground Paprika	0.67%
Water	3-10%
Mix 3-15 mins at Low Speed	
	100.00%

Following mixing of the dough in the mixer, the dough is allowed to rest for approximately 30-45 minutes. The time the dough is allowed to rest is called the "lay time." Usually, the dough is removed from the mixer and placed into a trough to rest during the lay time. At the end of the lay time, the dough



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is dumped into a hopper. A dough-hopper is positioned above a primary roller pair. The dough hopper feeds the dough between the primary roller pair to form a relatively thick sheet onto a first conveyor arrangement. The relatively thick dough sheet is reduced to a relatively thin dough sheet as it fed through a pair of spiral rollers along the first conveyor arrangement. The relatively thin sheet is then laminated about four times to form a layered dough ribbon across a second conveyor arrangement. Although not shown, the first and second conveyor arrangements can be part of the production line 14.

The ribbon 12 of layered dough can be moved in a first direction 24. A series of reduction roller pairs are arranged along a second conveyor arrangement of the production line 14. The rollers 16, 18, and 20 schematically represent the roller pairs. The ribbon 12 of layered dough is fed to between the reduction roller pairs 16, 18, 20 and reduced to a first thickness or height 86 (shown in FIG. 5). The first thickness is approximately three mm (0.1181 inch) in the exemplary embodiment of the invention. If necessary, further reductions can be used. The ribbon 12 may not be perfectly flat, but is substantially planar.

The third thickness of dough is the thickness prior to forming a discrete piece of dough with the cutting die 22. The ribbon 12 of dough at the third thickness moves along production line 14 to the cutting die 22. The ribbon 12 is moving along the production line 14 at 10-100 ft/min in the first direction 24 in the exemplary embodiment of the invention.

The method also includes the step of passing the ribbon 12 by the cutting die 22. In the exemplary embodiment of the invention, the ribbon 12 passes under the cutting die 22. FIG. 2 shows an exemplary cutting die 22a. The cutting die 22a is substantially cylindrical and includes at least one cavity defined by a surface 26a. The exemplary cutting die 22a includes a plurality of surfaces similar to surface 26a, each surface defining a cavity. The surface 26a corresponds to the desired shape of a discrete piece of dough. The surface 26a also corresponds to the desired shape of a discrete food product formed by further processing the discrete piece of dough, such as by baking. In alternative embodiments of the invention, one or more of the surfaces on the cutting die could be different from one another, resulting in the formation of differently shaped food products from a single cutting die.

In the exemplary cutting die 22a, the surface 26a is integrally formed with respect to a substantially cylindrical body portion 28a. The body portion 28a is rotated about its centered, longitudinal axis as the ribbon 12 is passed between the cutting die 22a and a surface 30a of a conveyor of the production line 14. FIGS. 3 and 4 show an alternative cutting die 22b that can be releasably connected to another structure. For example, the cutting die 22b can be bolted to a generally cylindrical body to be rotated about an axis. The generally cylindrical body may not be perfectly cylindrical to accommodate a planar back surface 32b of the cutting die 22b. A plurality of cutting dies similarly shaped to cutting die 22b could be bolted to a generally cylindrical body to be rotated about an axis. Alternatively, a plurality of differently shaped cutting dies could be bolted to a generally cylindrical body to be rotated about an axis to form differently shaped discrete pieces of dough.

The cutting die 22b moves in the first direction 24 with the ribbon 12. As set forth in the exemplary embodiment of the invention, the cutting die 22b is a rotating cutting die. When the cutting die 22b is engaging the ribbon 12, the cutting die 22b includes a first component of motion that is in the first direction and a second component of motion that is perpendicular to the first direction. Motion patterns of the cutting die

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other than rotation can be practiced with the invention. FIG. 12 shows a reciprocating die 22c.

Referring again to FIGS. 3-8, the surface 26b of the cutting die 22b includes a plateau portion 34b and a trench portion 36b surrounding the plateau portion 34b. An outer edge 38b of the trench portion 36b projects past the plateau portion 34b. In other words, outer edge 38b of the trench portion 36b is further from the back surface 32b than the plateau portion 34b. One or more docker pins 40b can extend from the plateau portion 34b. The docker pins 40b enhance consistent cooking of the food product.

The trench portion 36b includes a leading trench portion 42b, a trailing trench portion 44b, and two side trench portions 46b, 48b connect the leading and trailing trench portions 42b, 44b. The leading trench portion 42b defines a width 50b and an opening slope 52b. The trailing trench portion 44b defines a width 54b and an opening slope 56b. The width 50b is greater than the width 54b. In the exemplary embodiment of the invention, the width 50b is approximately eighteen percent greater than the width 54b. The opening slope 52b is greater than the opening slope 56b. In the exemplary embodiment of the invention, the opening slope 52b is thirty-three percent greater than the opening slope 56b. Thus, a larger volume is defined with a leading half of the cavity 26b than a trailing half of the cavity 26b. The differences in the widths 50b, 54b and opening slopes 52b, 56b between the leading and trailing trench portions 42b, 44b, respectively, are joined by a gentle blend defined in the side trench portions 46b, 48b.

FIGS. 5-8 show a sequence of detail process views in which a discrete piece of dough 58b is formed from a ribbon 12b passes the cutting die 22b. In FIG. 5, the cutting die 22b is being rotated in a direction 60b about an axis 62b. The direction 60b is rotational and includes a first component of motion in the first direction 24b. The ribbon 12b is formed with a plurality of layers 64b. As set forth above, the thickness of the ribbon 12b in the exemplary embodiment of the invention is about three mm (0.1181 inch).

In FIG. 6, both the cutting die 22b and the ribbon 12b have continued to move in the first direction 24b from the view shown in FIG. 5. A leading portion of the outer edge 38b pierces the ribbon 12b. The back surface 32b of the cutting die 22b and the surface 30b of the production line 14b form an angle 66b with respect to one another. Also, an edge 68b defined between the plateau portion 26b and the leading trench portion 42b contacts the ribbon 12b.

In FIG. 7, both the cutting die 22b and the ribbon 12b have continued to move in the first direction 24b from the view shown in FIG. 6. The angle 66b between the back surface 32b of the cutting die 22b and the surface 30b of the production line 14b still exists, although the value of the angle 66b has decreased from the value corresponding to FIG. 6. Dough from the ribbon 12b has been compressed and moved with the cutting die 22b to fill the trailing trench portion 44b. However, the leading trench portion 42b is not yet filled.

In FIG. 8, both the cutting die 22b and the ribbon 12b have continued to move in the first direction 24b from the view shown in FIG. 7. The back surface 32b of the cutting die 22b and the surface 30b of the production line 14b are now parallel with one another. The discrete piece 58b of dough has been substantially separated from the ribbon 12b, although some webbing may exist. The thickness of the discrete piece 58b between the plateau portion 34b and the surface 30b is approximately 0.036 inch. As a result, the ribbon 12b has been compressed approximately 69.5%. In alternative embodiments of the invention, the compression rate could be 60%-80%. The invention can be practiced wherein the compression rate is between 10%-80%.



The method also includes the step of displacing dough in the first direction to fill the cavity in the cutting die during the passing step. FIG. 8 also shows that dough from the ribbon 12b, including at least portions of the multiple layers 64b, has been displaced in the first direction to fill the leading portion 42b of the trench 36b. Dough has been moved forward, in the

76b, a top surface 78b, a planar portion 80b defined between the bottom surface 76b and the top surface 78b, and an raised portion 82b integrally formed with the planar portion 80b. The top surface 78b and the raised portion 82b cooperate to tub or trough. The table below provides exemplary dimensions of the food 74b:

TABLE 3

Sample	Weight (gm)				Height (mm)			
	Total	Planar Portion	Raised Portion	Raised (%)	Total	Planar Portion	Raised Portion	Raised (%)
1	43.7	29.2	14.5	33.2%				
2	44.6	29.8	14.8	33.2%				
3	44.3	30.4	13.9	31.4%				
4	44.3	29	15.3	34.5%	67.5	47	20.5	30.4%
5	44.4	29.3	15.1	34.0%	67	48	19	28.4%
6	43.8	28.7	15.1	34.5%	67	46	21	31.3%
7	43.4	31.3	12.1	27.9%	64	49	15	23.4%
8	43	30	13	30.2%	64	48	16	25.0%
9	43.5	29.7	13.8	31.7%	64	48	16	25.0%
10	39.7	27.1	12.6	31.7%				
11	40	26.6	13.4	33.5%				
12	40.1	27.3	12.8	31.9%				
13	39.6	25.3	14.3	36.1%	68	45.5	22.5	33.1%
14	39.7	26.8	12.9	32.5%	67	46	21	31.3%
15	43.4	30.5	12.9	29.7%	66	51	15	22.7%
16	43.4	30.6	12.8	29.5%	66	52	14	21.2%
17	43.8	31.2	12.6	28.8%	66.5	51	15.5	23.3%

first direction, during the process between the views shown in FIGS. 7 and 8. It is believed that approximately 61.4% of the dough of the discrete piece 58b is displaced to fill the trench portion 36b during the exemplary process.

As used herein, the amount of dough displaced refers to the amount of dough moved from a planar configuration to an raised configuration. The ribbon 12b defines a planar configuration before passing the cutting die 22b. The discrete piece of dough 58b includes a portion that is of planar configuration and a portion that is of raised configuration extending from the portion of planar configuration; a raised portion 70b in the exemplary embodiment of the invention fills the trench portion 36b of the surface/cavity 26b. The planar portion 72b of the discrete piece 58b extends between the surface 30b and a plane including, but not limited to, the plateau surface 26b. In alternative embodiments of the invention, 50%-70% may be displaced. It is believed that the invention can be practiced wherein 10%-80% of the dough is displaced.

The process illustrated in FIGS. 5-8 and described above results in a portion of the ribbon 12, the raised portion 70b, being permanently displaced to a second height 88b greater than the first height 86b. The second height 88b of the dough increases 39.4% from the first height in the exemplary embodiment of the invention. As set forth above, the thickness of the ribbon 12b is approximately 0.1181 inch prior to passing the cutting die 22b. The height of the raised portion 70b in combination with the height of the planar portion 72b is approximately 0.195 inch in the exemplary embodiment of the invention. Thus, the maximum height of the dough increases 39.4%. In alternative embodiments of the invention, it is believed that the maximum height of the dough can be increased 20%-60%.

After the discrete piece 58b of dough has been formed by the cooperation between the cutting die 22b and the moving ribbon 12b, the discrete piece 58b of dough can be further processed to form a food product. The discrete piece 58b can be baked to form an exemplary food product 74b, as shown in FIGS. 9-11. The food product 74b includes a bottom surface

Each sample of Table 2 includes ten individual pieces of the food product 74b. Thus, each value in the total weight column is the weight of ten crackers. Each value in the total height column is the height of ten crackers stacked on top of one another. With reference to FIG. 10, the planar portion 80b and the raised portion 82b are distinguished from one another at the line 84b. The table shows that The second or raised portion 82b of the food product 74b can be between 25% and 40% of the cracker by weight. The second or raised portion 82b of the food product 74b can be between 20% and 40% of a height of the cracker.

FIGS. 13 and 14 show an alternative food product 74d formed according to an alternative embodiment of the invention. The food product 74d includes a raised portion 82d shaped like a grid. The raised portion 82d extends from a planar portion 80d having a top surface 78d.

The foregoing invention has been described in accordance with the relevant legal standards, thus the description is exemplary rather than limiting in nature. Variations and modifications to the disclosed embodiment may become apparent to those skilled in the art and do come within the scope of the invention. For example, food products shaped differently than tub-shaped food products can be produced according to the invention. Food products produced according to the invention can include raised portions that are shaped like letters, text, symbols, grid patterns, or any other desired shape. Accordingly, the scope of legal protection afforded this invention can only be determined by studying the following claims.

What is claimed is:

1. A method of forming an edible item comprising the steps of:

- forming a unitary cutting die;
- forming dough being at least partially elastic into a substantially planar ribbon having a first height;
- permanently displacing a portion of the at least partially elastic ribbon to a second height greater than the first height with the unitary cutting die; and



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- cutting a discrete piece of dough from the at least partially elastic ribbon with the unitary cutting die to form the edible item;
- wherein the permanently displacing step and the cutting step are preformed simultaneously to one another with the unitary cutting die having a surface defining a cavity for displacing the portion of the at least partially elastic ribbon and an outer edge formed integrally with the surface for cutting the discrete piece of dough and defining the cavity with the cutting die having a leading trench defining the cavity with the cutting die having a leading trench portion with a first width and a first opening slope to a define a first volume and trench portion with a second width and a second opening slope to define a second volume wherein the first volume of the leading trench portion is larger than the second volume of the trailing trench portion.
2. The method of claim 1 wherein said permanently displacing step further comprises the steps of:
- permanently elevating a first portion of the dough from the first height to the second height; and
  - permanently compressing a second portion of the dough from the first height to a third height less than the first height.
3. The method of claim 1 wherein said permanently displacing step further comprises the step of:
- forming the displaced portion as a ring surrounding and integrally formed with a substantially flat surface to define a trough.
4. The method of claim 1 wherein said permanently displacing step further comprises the step of:
- forming the displaced portion as a grid projecting from and integrally formed with a substantially flat surface.
5. The method of claim 1 further comprising the steps of:
- moving the at least partially elastic ribbon of dough in a first direction;
  - moving the cutting die in the first direction during said permanently displacing step.
6. The method of claim 5 further comprising the step of:
- displacing a portion of the at least partially elastic ribbon in the first direction to fill a cavity in the cutting die during said permanently displacing step.
7. The method of claim 5 wherein said moving step is further defined as:
- moving the at least partially elastic ribbon of dough in the first direction at a speed of between ten and one hundred feet per minute.
8. The method of claim 5 wherein said step of moving the cutting die is further defined as:

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- rotating the cutting die such that movement of the cutting die includes a first component in the first direction with the ribbon and includes a second component of motion perpendicular to the first direction and to the ribbon.
9. The method of claim 5 wherein said step of moving the cutting die is further defined as:
- reciprocating the die between an elevated position spaced from the at least partially elastic ribbon and a lowered position engaging the at least partially elastic ribbon.
10. The method of claim 1 wherein said forming step includes the step of:
- laminating the dough to form the at least partially elastic ribbon with multiple layers, wherein at least portions of the multiple layers are displaced during said permanently displacing step.
11. The method of claim 1 wherein said permanently displacing step includes the step of:
- filling the trailing trench portion of the cavity before the leading trench portion.
12. A method of forming an edible item comprising the steps of:
- forming a unitary cutting die;
  - forming dough being at least partially elastic into a substantially planar ribbon having a first height;
  - cutting a discrete piece of dough from the at least partially elastic ribbon with the unitary cutting die;
  - permanently displacing a portion of the at least partially elastic ribbon to a second height greater than the first height with the unitary cutting die; and
  - baking the cut, discrete piece of dough having the permanently displaced portion to form a snack with an raised portion;
- wherein the permanently displacing step and the cutting step are preformed simultaneously to one another with the unitary cutting die having a surface defining a cavity for displacing the portion of the at least partially elastic ribbon and an outer edge formed integrally with the surface for cutting the discrete piece of dough and defining the cavity with the cutting die having a leading trench defining the cavity with the cutting die having a leading trench portion with a first width and a first opening slope to a define a first volume and trench portion with a second width and a second opening slope to define a second volume wherein the first volume of the leading trench portion is larger than the second volume of the trailing trench portion.

\* \* \* \* \*

UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 7,914,834 B2  
APPLICATION NO. : 11/453510  
DATED : March 29, 2011  
INVENTOR(S) : Bin Fu, Don Barnes and Suzanne Annette Devyak

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Figure 5: The lead line for reference numeral "62b" should be touching a "+" symbol similar to Figures 6 & 7.

Figure 8: The lead line for reference numeral "62b" should be touching a "+" symbol similar to Figures 6 & 7.

Column 9, Line 9, Claim 1: "dough" should read -- dough, --.

Column 10, Line 22, Claim 12: "die:" should read -- die, --.

Column 10, Line 38, Claim 12: "dough" should read -- dough, --.

Signed and Sealed this  
Twenty-first Day of August, 2012

A handwritten signature in black ink that reads "David J. Kappos". The signature is written in a cursive style with a large initial "D" and a stylized "K".

David J. Kappos  
*Director of the United States Patent and Trademark Office*